

Date: Monday, 11/19/2007 4:05:11 PM
User: Kim Johnston

34

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : CABIN FLOOR PROTECTOR
Job Number : 35866	
Estimate Number : 12766	
P.O. Number : <u>N/A</u>	Part Number : D35753
This Issue : 11/19/2007 S.O. No. : <u>N/A</u>	Drawing Number : D3575 REV.A
Prsht Rev. : NC	Project Number : N/A
First Issue : <u>N/A</u> Type : SMALL /MED FAB	Drawing Revision : A
Previous Run : 33398	Material : <u>N/A</u>
Written By : <u>[Signature]</u>	Due Date : 12/5/2007 Qty: 3 Um: Each
Checked & Approved By : <u>[Signature] 07/11/20</u>	
Comment : Est Rev : A New Issue 07-01-22 EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	F60029	lexan grey
-----	--------	------------



Comment: Qty.: 10.6660 sf(s)/Unit Total : 31.9980 sf(s)

F60029 lexan sheet

Batch: 105330 IB 07-11-22

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET

1-Cut as per Dwg D3575

Dwg Rev: A

Prog Rev: A

IB 07-11-22

(3)

2-Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



IB 07-11-22

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

5 07/14/23 (x3)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr if necessary.

SAD 07-11-25 (3)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: FD Date: 5/11/27
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 11/19/2007 4:05:11 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CABIN FLOOR PROTECTOR

Job Number: 35866

Part Number: D35753

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/11/26 (X3)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N using a permanent fine point marker, then Stock

Location:

35818

07/11/27 (X3)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/11/27 (X3)

Job Completion



07/11/28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

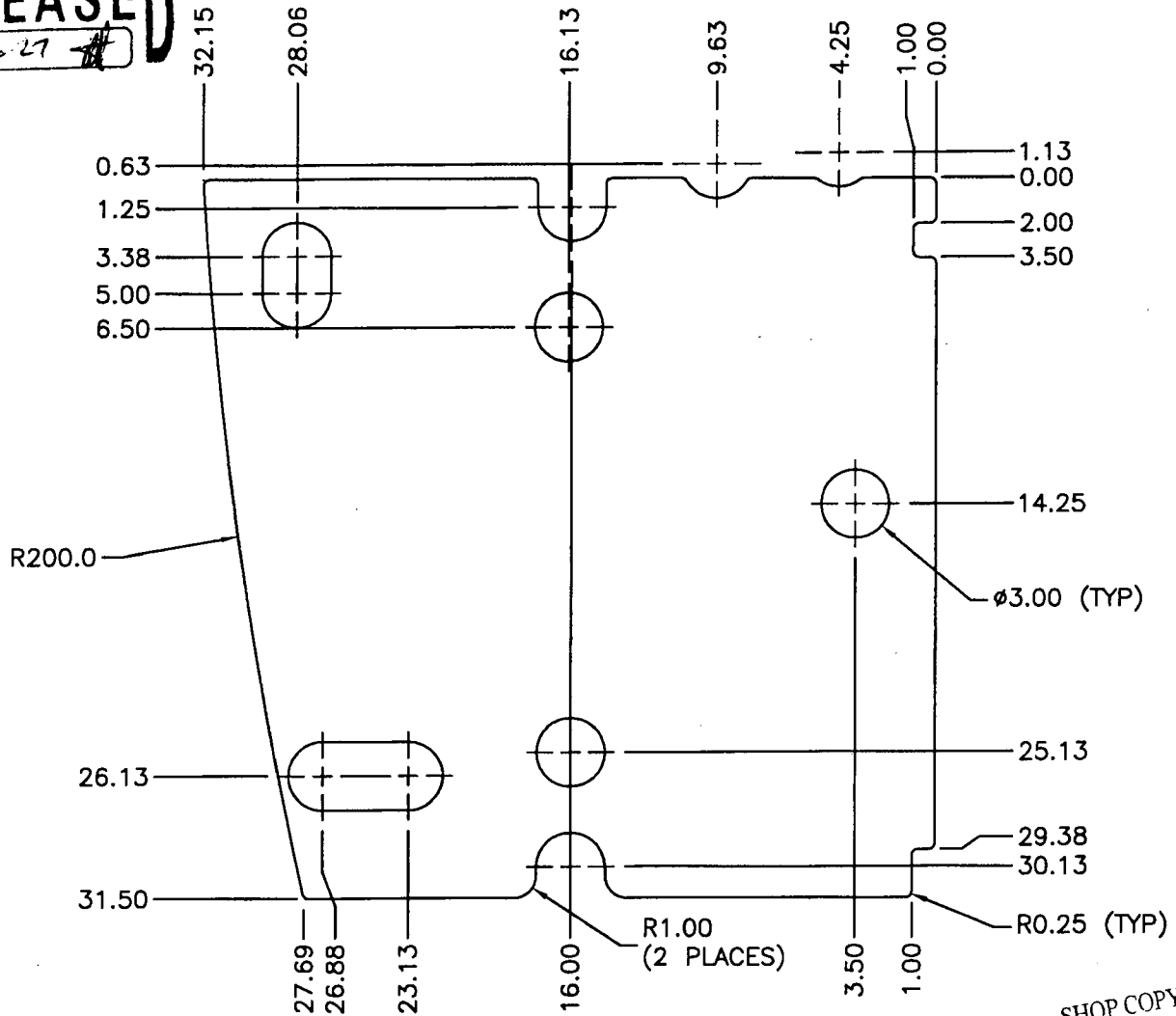
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B		Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng				

NOTE: Date & initial all entries

DART

DESIGN <i>LE</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>#</i>	DRAWING NO. D3575	REV. A SHEET 1 OF 4
DATE 07.06.08	TITLE CABIN FLOOR PROTECTOR	SCALE 1:8	
A	07.06.08	NEW ISSUE	

RELEASED
07.06.27 *#*

D3575-1 CABIN FLOOR PROTECTOR (SHOWN)
D3575-2 CABIN FLOOR PROTECTOR (OPPOSITE)

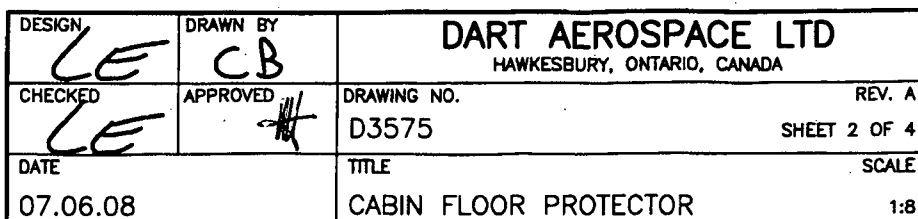
NOTES:

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3575-1/-2" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8966

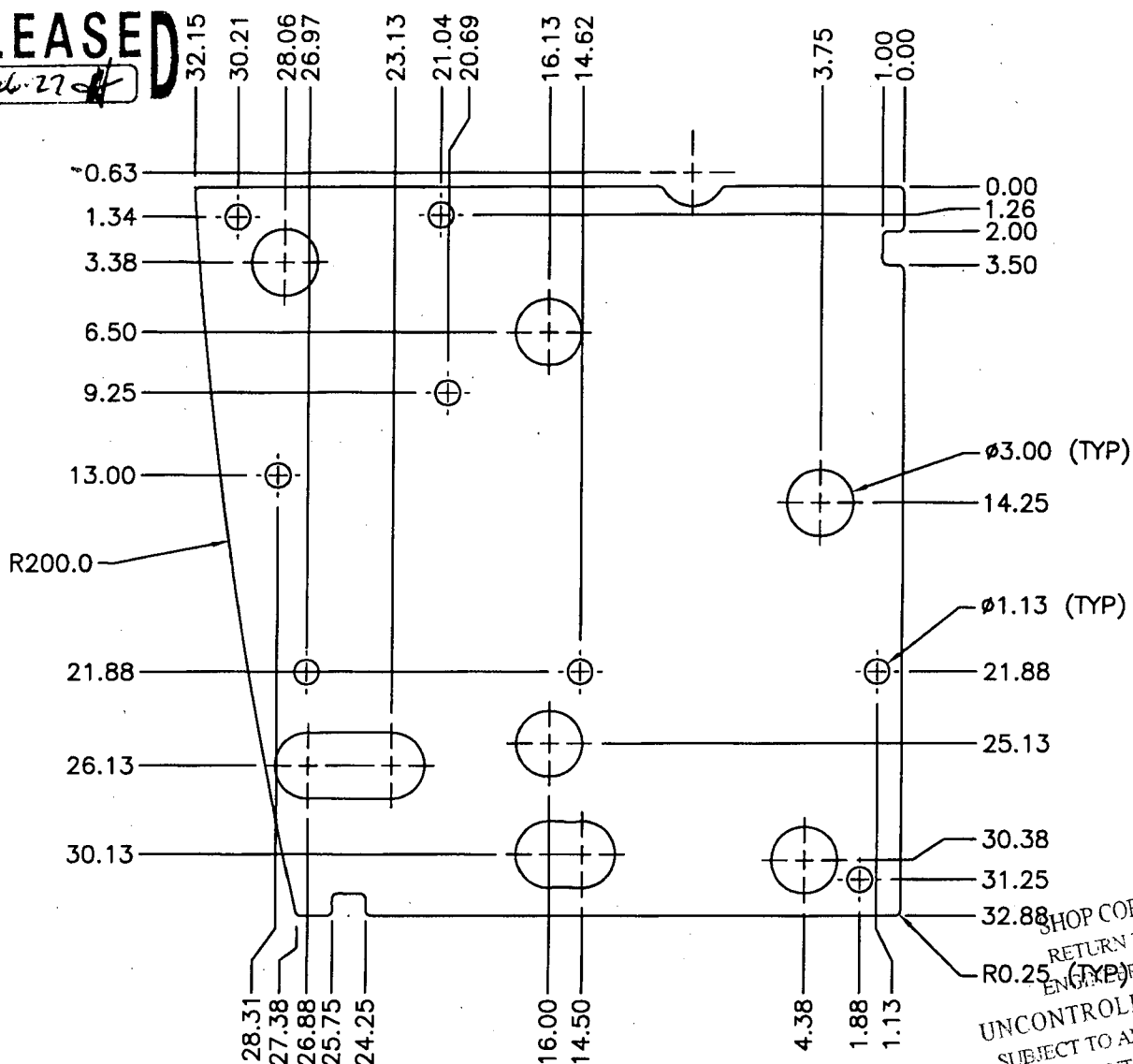
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RELEASED
07-06-27



31.25
- 32.88
- R0.25 (TYPE)
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WORK ORDER
NO. 35866

NOTES:

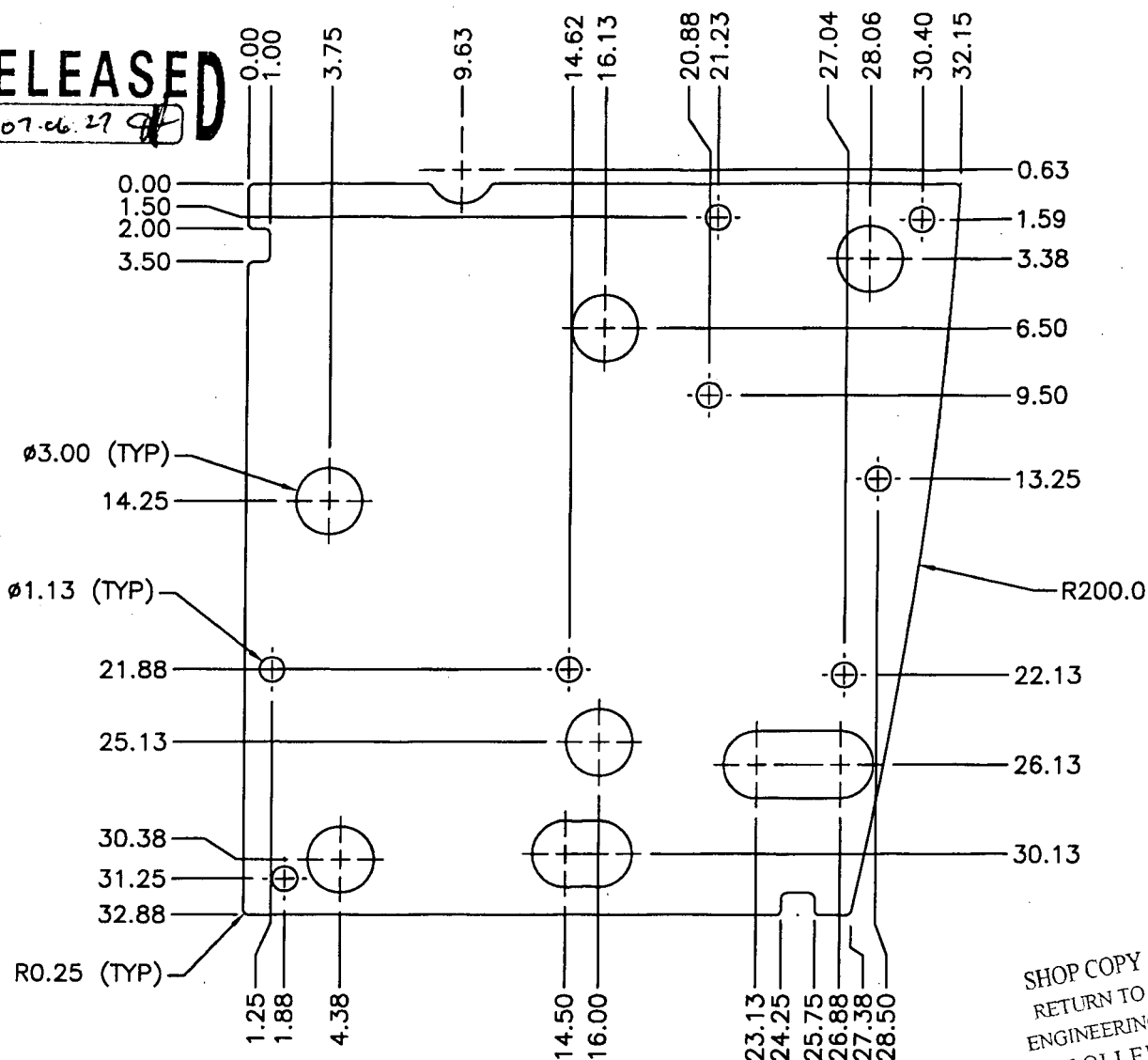
- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3575-3" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8967

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DART

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CHECKED <i>LE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3575	REV. A SHEET 3 OF 4
DATE 07.06.08		TITLE CABIN FLOOR PROTECTOR	SCALE 1:8

RELEASED
07.06.27**D3575-4 CABIN FLOOR PROTECTOR****NOTES:**

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125" THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3575-4" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8968

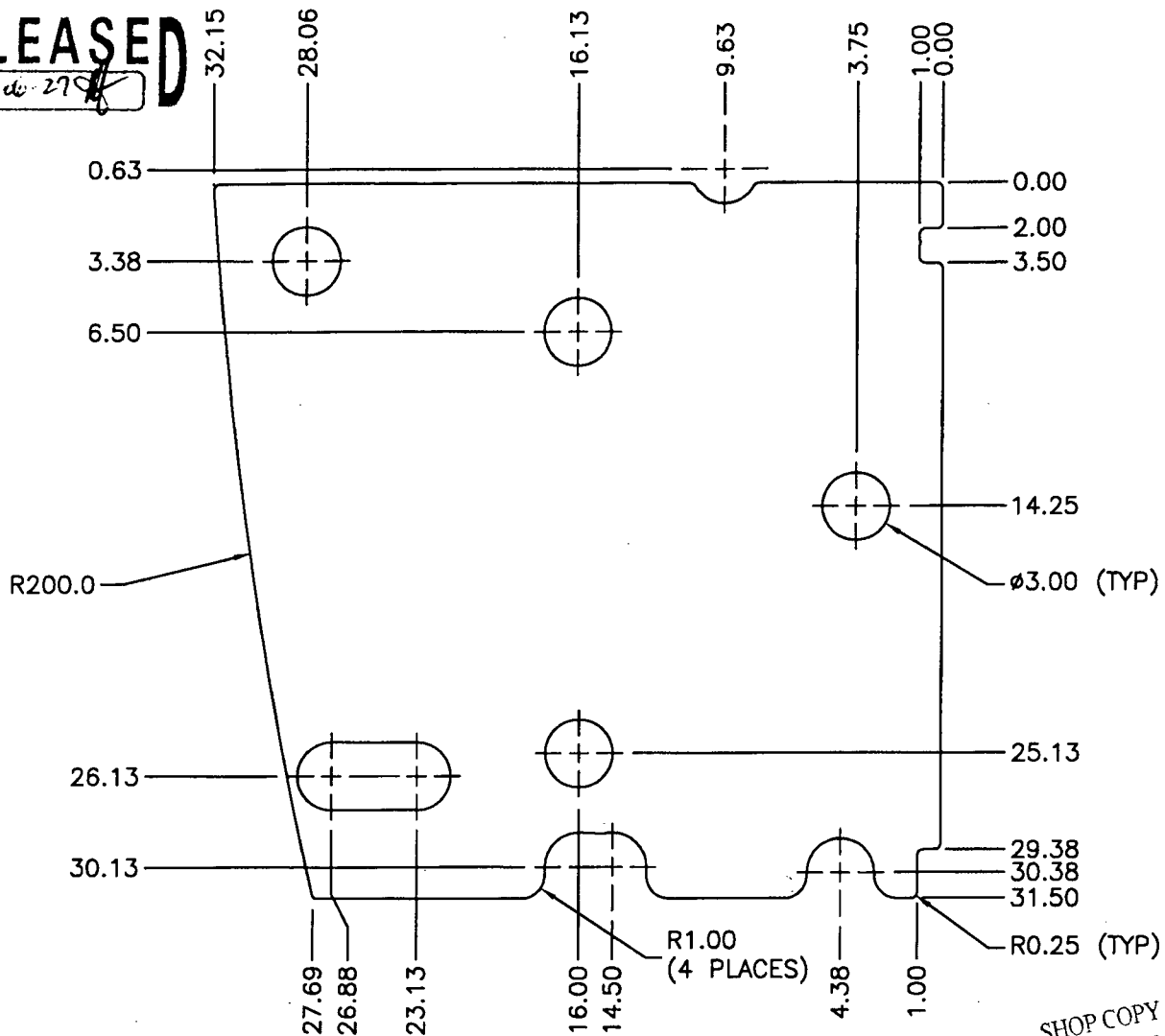
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DART

DESIGN <i>LE</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>H</i>	DRAWING NO. D3575	REV. A SHEET 4 OF 4
DATE 07.06.08		TITLE CABIN FLOOR PROTECTOR	SCALE 1:8

RELEASED
07-06-27

D3575-5 CABIN FLOOR PROTECTOR (SHOWN)
D3575-6 CABIN FLOOR PROTECTOR (OPPOSITE)

NOTES:

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3575-5/-6" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8969

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DART AEROSPACE LTD		Work Order: 35866
Description: CABIN FLOOR PROTECTOR		Part Number: D3575-3
Inspection Dwg: D3575-3 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø 1.13	+ .004 - .001	1.131	X			
Ø 3.00	+ .006 - .001	3.004	X			
1.00	+/- .030	1.00	X			
3.75	+/- .030	3.75	X			
14.62	+/- .030	14.62	X			
16.13	+/- .030	16.13	X			
20.69	+/- .030	20.69	X			
21.04	+/- .030	21.04	X			
23.13	+/- .030	23.13	X			
26.91	+/- .030	26.91	X			
28.06	+/- .030	28.06	X			
30.21	+/- .030	30.21	X			
32.15	+/- .030	32.15	X			
1.13	+/- .030	1.13	X			
1.88	+/- .030	1.88	X			
4.38	+/- .030	4.38	X			
14.50	+/- .030	14.50	X			
16.00	+/- .030	16.00	X			
24.25	+/- .030	24.25	X			
25.75	+/- .030	25.75	X			
26.88	+/- .030	26.88				
27.38	+/- .030	27.38				
28.31	+/- .030	28.31				

Measured by: HB
Date: 07-11-27

Audited by: S
Date: 7/11/23

Prototype Approval: M
Date: 7/12

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

